Page 1

March-17-14 10:03:08 A	4 <i>M</i>		1 14	() ()						
tem ID: D3492- Revision ID: tem Name: Plug		Acc	cept	*N9	<u> </u>	100	⊁ Se	etup Start Stop	ı V.	S1* S2*
Start Date: 3/17/14 Required Date: 3/31/14		*160* *160*			Item ID: omer:					
Reference: Approvals: Proces QC:	·		Γooling: SPC (Y/N):		Date:		R	un Start Stop	1/11	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Too	l ID Tool#		Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3492	E		0.00				· 			
*100 *100* Hardinge Hardinge CNC Lathe Small	Hardinge CNC LATHE SMALI Memo 1-Turn as per Folio Dwg Rev: E Folio Rev: E	FA633 & Dwg D3492	0.00 DAS	14/0	3/26		169	J	<u>.</u>	/14/03/
110	QC2- Inspect parts off machine	FAI/FAIB	0.00							[14/03]
110 QC Quality Control	Memo		DA: 44	14/0	03/26		169			/.14/03/
120	QC8- Inspect parts - second ch	eck	0.00				17		,	DAS 40
120 QC Quality Control	Memo		0.00				169	Ø		9-89 14/03/2

DQA:			Date:												
						WORK ORDER NON	-CC	ONFO	RMANCE / UP	DATE				AEROSPACE	
QA Closed:			Date:							١	Nork Order u	odate only			
Work Orde	er:					DISPOSITION		•	AGAINST DEPARTMENT/PROCESS						
	•				_	Rework	1		Skid-tube	Crosstube	\neg	Water Jet	T F	ingineering	
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality	
	•					Use-as-is	1		noforming	Finishing	_	re/Packaging	7	Other	
NCR f	No.					Suspected Unapproved	1		Large Fab	Composite	7	Supplier			
															
Root					Desc	ription of work order update	1	nitial	Acti	on	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	n	QC Inspector	
Design															
Doc/Data							•						į		
Equip/Tooling		·													
Handling/Pre															
Material															
Operator							İ								
Offset/Setup															
Process								•					į		
Supplier								2-call							
Training															
Transport													1		
Unapproved					<u> </u>				<u>L</u>						
							FA	ULT CA	TEGORY						
Landi		t				General ,	_	1 ,-		г	–				
	_	Bending			.	Bend	\vdash	1	Program		Outside Dim			essure/Forced	
		1	ot Concer	ntric	\vdash	BOM/Route	\vdash	Grain		• -	Over/Under	1		t-up	
		Cracks	1 /5: 1	4	<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorre		_	mperature/Cure	
	_	Crimp/Kii	nk/Rippie	/Wave	 	Burrs	_	1	ion Incomplete/Un	· -	Part Lost/M	issing	Ш <u>"</u>		
	<u> </u>	Cuffs			_	Contamination	\vdash	4	tions Incomplete/U	nclear	Part Moved		ШWı	rong Stock Pulled	
* .	<u> </u>	Crushing			-	Countersink	\vdash	•	gned/off center	-	Positioned V		— .		
	\vdash	Heat Trea		T b	-	Cut Too Short	\vdash	Mislabe		L	Power Loss/	Surge	Ot	ner	
	\vdash	Inspectio	-	ıupe	-	Drawing	\vdash	Misrea							
	\vdash	Marks/Ch			-	Drill Holes	\vdash	Off-set							
	-	Turning S	-		_	Finish	<u></u>	4	Calibration						
		Wave/Tw	vist in Tub	e e		Fit/Function		Out of	it of Sequence						

114879 Work Order ID 114879

March-17-14 10:03:08 AM

Item ID:

D3492-1

Accept

N900040100

Setup Start *NC1*

Revision ID:

Item Name: Start Date:

Plug

3/17/14

Start Oty: 160.00

160

Cust Item ID:

Required Date: 3/31/14

Req'd Qty: 160.00

160

Customer:

Tool ID

Reference:

Process Plan: Approvals:

Date: Date:

Tooling:

Date:

Run

OC:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Operation Description

Set Up/ Run Hours

Accept Tool # Plan Oty Oty Code

Reject Reject Number Stamp

150

150

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

0.00

0.00

169 2B14-3-28

Hand Finishing

160

170

QC

160 Powdercoat

Powder Coating

Memo

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

(Flat End Only) START TIME: OVEN TEMPERATU FINISH TIME:

DAS

27 0.00

OC3-Inspect Part Finish

170

Quality Control

Memo

169 b 14-4-1

169

DQA:			Date:			WORK ORDER MON	-CONFORMANCE / UPDATE							
QA Closed:			Date:			WORK ORDER NON-	-C(JNFOI	RIVIAINCE / U		Work Order update only			
Work Orde	ır.					DISPOSITION				AGAINST	DE	PARTMENT,	PROCESS	.
Part N	 lo				_	Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	ing Small Fab Prod. Eng. Coor. ing Finishing Rec/Store/Packaging		Engineering Quality Other		
Root					Desci	ription of work order update	i	nitial	Act	tion		Sign &		
Cause	ļ	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved								Description						
. ,			<u> </u>		L	· · · · = · · · · · · ·	FAI	ULT CAT	EGORY					_
Landir	ng G	ear				General	FA	ULT CAT	EGORY					
		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection	nk/Ripple t n Strip in atter	e/Wave Tube	_	Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/U ions Incomplete/ ined/off center eled	-		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
ľ		Turning S	-			Finish	<u> </u>	1	Calibration					
		Wave/Tw	ist in Tul	be		Fit/Function		Out of S	Sequence					

Work Order ID 114879

114879

March-17-14 10:03:08 AM

Required Date: 3/31/14

Item ID:

D3492-1

Accept

N900040100

Setup Start

Revision ID:

Item Name: **Start Date:**

Plug

3/17/14

Start Qty: 160.00 Req'd Qty: 160.00

160 *160*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

x169 & Il worder

Sequence ID/

Operation Description Work Center ID

Identify as per dwg & Stock Location: 1266

Set Up/ **Run Hours**

Tool ID

Accept Tool # Plan Qty Code

Reject **Qty**

Stop

Reject Insp. Number

Stamp

120 Packaging

Memo

0.00

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

Quality Control

QC

Memo

0.00

M14-04-2 4-04-01

DQA:		Date:										TRAGG	
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UP		ork Order up	date only		AEROSPACE
NA/only Ondon					DISPOSITION	-		AGAINST DEPARTMENT/PROCESS					
Work Order:				<u> </u>	Rework	۱		Skid-tube	Crosstube	1	Water Jet		Engineering
Part No	,			:	Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	_	Quality
1 411110	•			_	Use-as-is			· ·	Finishing	-1	e/Packaging		Other
NCR No	·			_	Suspected Unapproved		Thermoforming Finish Large Fab Compos						
Root			,	Desc	ription of work order update		nitial	Actio	on	Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	ก	QC Inspector
Design		Į .											
Doc/Data											I		
Equip/Tooling	_										:		
Handling/Pre													
Material ,	4												
Operator	4										i		
Offset/Setup	_												
Process	_					ł							
Supplier													
Training	_												
Transport	4												
Unapproved		<u> </u>								<u> </u>			
						FA	ULT CA	regory				_	
Landing	_			_	General		1- " /-			1		$\overline{}$	l
<u> </u>	Bending	- . C		-	Bend BOM/Boute	-	1	rogram		Outside Dim		<u> </u>	Pressure/Forced
<u> </u>	-	ot Concer	זנרוכ		BOM/Route	\vdash	Grain		-	Over/Under			Set-up
<u> </u>	Cracks	nk/Binnla	Maria		Broken/Damage/Defect	<u> </u>	Hardwa		avalities d	Part Incorred		-	Temperature/Cure
i ⊢	Cuffs	nk/Ripple	y wave		Burrs Contamination		4	ion Incomplete/Und	· —	Part Lost/Mi	ssing	-	Weld
-				-	4		4	ions Incomplete/U	nciear	Part Moved	l/rong		Wrong Stock Pulled
 	Crushing Heat Tre			\vdash	Countersink Cut Too Short	-	Mislabe	gned/off center	 -	Positioned V	- 1	$\overline{}$	Other
-		at on Strip in	Tubo	\vdash	Drawing	\vdash	Misrea		Ĺ	Power Loss/	ouige		Totilet
 	Marks/C	•	iune	-	Drill Holes	-	Off-set					_	
 		naccer Sequence		\vdash	Finish	\vdash	4			 			
-	_	vist in Tuk		\vdash	Fit/Function	Out of Calibration Out of Sequence							
1 1	IAAGAG IA	AISCHI I MY	<i>-</i>	- 1	programedon	1	jour or.	Jequence					

Picklist Print

March-17-14 10:03:13 AM

Work Order ID: 114879

D3492-1

Parent Item Name: Plug

114879

D3492-1

Start Date: 3/17/14

Required Date: 3/31/14

Start Qty: 160.00

Required Qty: 160.00

Comments:

Parent Item:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

M6061T6R0.625 Purchased No 100 f 44.4295 0.	0.0625 11	

M6061T6R0 625 6061-T6 Round Bar .625"

Location	Loc Oty	Loc Code
MAT012	44.429474	
m126726	8.429474	
¥ m128265 ∜	36	

DQA:			Date:										Ì	
						WORK ORDER NON	-C(ONFO	RMANCE / UF			_	_	AEROSPACE
QA Closed:			Date:							V	ork Order up	date only		
Work Orde	r:					DISPOSITION			AGAINST DEPARTMENT/PROCESS					
	•					Rework	1		Skid-tube	Crosstube	٦	Water Jet	\neg	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	ヿ	Quality
	•					Use-as-is	1	Therr	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite		Supplier		
Root					Desc	ription of work order update		Initial	Act	ion	Sign &	· · · · · · · · · · · · · · · · · · ·	Т	
Cause		Date	Step	Qty		or non-conformance	Ct	nief Eng	Descr	iption	Date	Verification		QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre													Ì	
Material													-	
Operator													İ	
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved					<u> </u>									
							FA	ULT CA	TEGORY					
Landir	ng (General	_	7 /-		Г	٦	. г		- 1-
		Bending			-	Bend	-	4	Program	-	Outside Dim	⊢	$\overline{}$	Pressure/Forced
		Centre N	ot Concer	ntric	-	BOM/Route	-	Grain		<u> </u>	Over/Under	-	$\overline{}$	Set-up
		Cracks	. 1. /p: (-	444	-	Broken/Damage/Defect	-	Hardwa		116 1	Part Incorre	ļ	_	Temperature/Cure
		Crimp/Kii	nk/Rippie	/wave	-	Burrs	\vdash	⊣ `	ion Incomplete/Ur	· —	Part Lost/M	issing	—	Weld
		Cuffs			\vdash	Countains	-	4	tions Incomplete/U	unclear	Part Moved	<u>L</u>	'لـــ	Wrong Stock Pulled
		Crushing			-	Countersink	\vdash	⊣	gned/off center	-	Positioned V			Othor
	_	Heat Trea		Tuba	-	Cut Too Short	\vdash	Mislab		Ĺ	Power Loss/	ourge [Other
	-	Inspectio		tube	\vdash	Drawing Drill Holos	\vdash	Misrea				<u> </u>		
	\vdash	Marks/Ch			-	Drill Holes	-	Off-set						
	\vdash	Turning S			\vdash	Finish Fit /Function	\vdash	-	Out of Calibration					
		Wave/Tw	rist in Tub	<u>ле</u>		Fit/Function		Jour of	Sequence					

DART AEROSPACE LTD	Work Order:	114879
	Part Number:	D3492-1
Description: Plug		Page 1 of 1
Inspection Dwg: D3492 Rev: E		, ugo . o

FIRST ARTICLE INSPECTION CHECKLIST

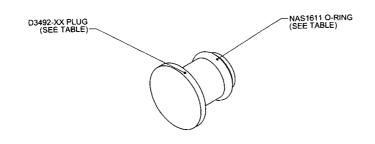
	11101	-T			Method of	
Drawing	Tolerance	Actual Dimension	Accept	Reject	Inspection	Comments
Dimension					FK-04	Vern.
0.060	+/-0.005	, OPO				VCIV -
0.060	+/-0.005	, 060	7		hy hy	
Ø0.394	+/-0.010	. 393	7		h	<u></u>
Ø0.625	+/-0.010	620	7		h	<u> </u>
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0.050 x 20°	+/-0.010	05x CEO.			4	1
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			-	-		
	-					
	DAS		DA	8		

Measured by: 9-89 | Audited by: 9-89 | Preliminary Approval: |

Date: 14/03/24 | Date: 14/03/27 | Date: |

			Revised by	Approved
Rev	Date	Change	KJ/JLM	
A	06.06.02	New Issue P/O D3492-041	KJ/JLM	
	06.10.16	Ø0.625 was Ø0.500	KJ/EC/DD	1
	07.11.23	Tolerances revised	KJ/DD	
	08.06.19	0.050 x 20° dimension added	1/ 1	-
E	11.07.26	Dimensions updated per Dwg Rev D	KJ KJ	
	14.01.21	Dwg Rev updated	KJ 981	<i>[4</i> 40]
	14.01.21	Digitotop	0	

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D3492-XXX PLUG PARTS LIST

1		<u> </u>	<u> </u>	<u> </u>	D349					
ļ	DESCRIPTION	PART NUMBER	QTY -055	QTY -053	QTY -051	QTY -049	QTY -047	QTY -045	QTY -043	QTY -041
1	PLUG ASSEMBLY	D3492-041						- 0.10	-040	X
1	PLUG ASSEMBLY	D3492-043				i		_	X	
1	PLUG ASSEMBLY	D3492-045						x	 ^ -	
1	PLUG ASSEMBLY	D3492-047					х	<u> </u>		
1	PLUG ASSEMBLY	D3492-049				x		_		
	PLUG ASSEMBLY	D3492-051			X					-
١,	PLUG ASSEMBLY	D3492-053		х				 		
]Æ	PLUG ASSEMBLY	D3492-055	Х	-	T		-		-	-
1					1	 	-	-		-
Į	PLUG	D3492-1			1			-		1
4	PLUG	D3492-3	-		1	 	1		1	<u> </u>
4	PLUG	D3492-5						1		
1	PLUG	D3492-7				1	1	- -		
1	PLUG	D3492-9			†	1	<u> </u>	1 -	 	├
_	PLUG	D3492-11	T		1	1			 -	<u> </u>
۱,	PLUG	D3492-13		1				1		
Æ	PLUG	D3492-15	1		1			 	+-	
4			T	\vdash		1	1	+	+	
4	O-RING	NAS1611-005			1	1		1	-	
_	O-RING	NAS1611-007		1	+-		1	+	+	
4	O-RING	NAS1611-010	1		-		<u></u>	+	+	1
4	O-RING	NAS1611-012	1	1		 	1	+	+	<u> </u>
4	O-RING	NAS1611-013			1		+	+	1	-
4	O-RING	NAS1611-015	1		1	1		+-	+ -	\vdash
١	O-RING	NAS1611-016		_	+-	1	+-	+-	-	<u> </u>

NOTES: 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

114879 MUS 1403-17

REV.	DESCRIPTION	BY	DATE
Α	NEW ISSUE	PH	06.01.04
В	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
С	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
E	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08

DESIGN	PH	DART AEROSPACE LTD		
DRAWN	ΑP	HAWKESBURY, ONTARIO, CANADA		
CHECKED	A35	DRAWING NO.	REV. E	
MFG. APPR.	, <u>N</u>	D3492	SHEET 1 OF 2	
APPROVED	10	TITLE	SCALE	
DE APPR.	- <i>- 3</i> 4	PLUG	NTS	
D. 25	08.08	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS GOODARD IS SHOWLE AND CONFORTINA AND IS SUPPLIED ON THE COPIESS CONSTITUTING THE NOT TO BE USED FOR ANY PARROSE OF COORDINATION OF THE OFFICE SHOWN WITHOUT		

